

Date: Wednesday, 1/23/2008 11:35:53 AM
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : MIRROR BRACKET
Job Number : 36919	
Estimate Number : 10142	
P.O. Number :	Part Number : D2161204
This Issue : 1/23/2008 S.O. No. :	Drawing Number : D2161 REV B2
Prsht Rev. : NC	Project Number : N/A
First Issue : 1/1 Type : SMALL /MED FAB	Drawing Revision : B2
Previous Run : 36886	Material :
Written By :	Due Date : 1/30/2008 Qty: 5 Um: Each
Checked & Approved By : <u>08 01 23</u>	
Comment : Est Rev:A New Issue 05-11-01 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	36919A D2013-5	FC 08 02 21 (4)
2.0	36919B D2013-6	FC 08 02 21 (4)
3.0	36919C D2037-101	FC 08 02 21 (4)
4.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Assemble on Jig DT8065 as per Dwg D2161

FC

08/02/21 (4)

2-Weld as per Dwg D2161 Identify as D2161-204

FC

5.0 DO NOT USE WELD INSPECTION



QCS: →



QCS

08/02/21 (4)

Comment: WELD INSPECTION

QC9 ⇒ PD 08-02-21 (4)

6.0 POWDER COATING POWDER COATING



M100 700



Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

M-1

08-02-21 (4)

7.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



(4)

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

M-1

01/02/25

8.0 QC21 FINAL INSPECTION/W/O RELEASE



(4)

Comment: FINAL INSPECTION/W/O RELEASE

08/02/25

Job Completion



2008/2/25

(4)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: D Date: 08/02/22
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08.02.22	4.0	D2037-101 HAS A0323 on one side only. Should be 2 ends.	LE 08.02.22	Drill opened .257 → .323. As per hand change in Dwg.	FF 08/02/22	EB 08/02/22	LE 08.02.22	<u> </u> 08.02.22

NOTE: Date & initial all entries



DESIGN	DRAWN BY	DART AEROSPACE LTD	REV. B
JB	RT	HAWKESBURY, ONTARIO, CANADA	
CHECKED KE	APPROVED RT	DRAWING NO.	SHEET 1 OF 1
DATE 99.06.07		TITLE MIRROR BRACKET	SCALE NTS
A	93.04.29	NEW ISSUE	
B	99.06.07	REDRAWN FOR CLARITY ADDED -204/-205/-212 DESIGNATIONS	
B1	02.03.25	CHANGE FINISH	
B2	02.06.14	D2037-101 WELD FLAT	

RELEASED
KE 99.06.10

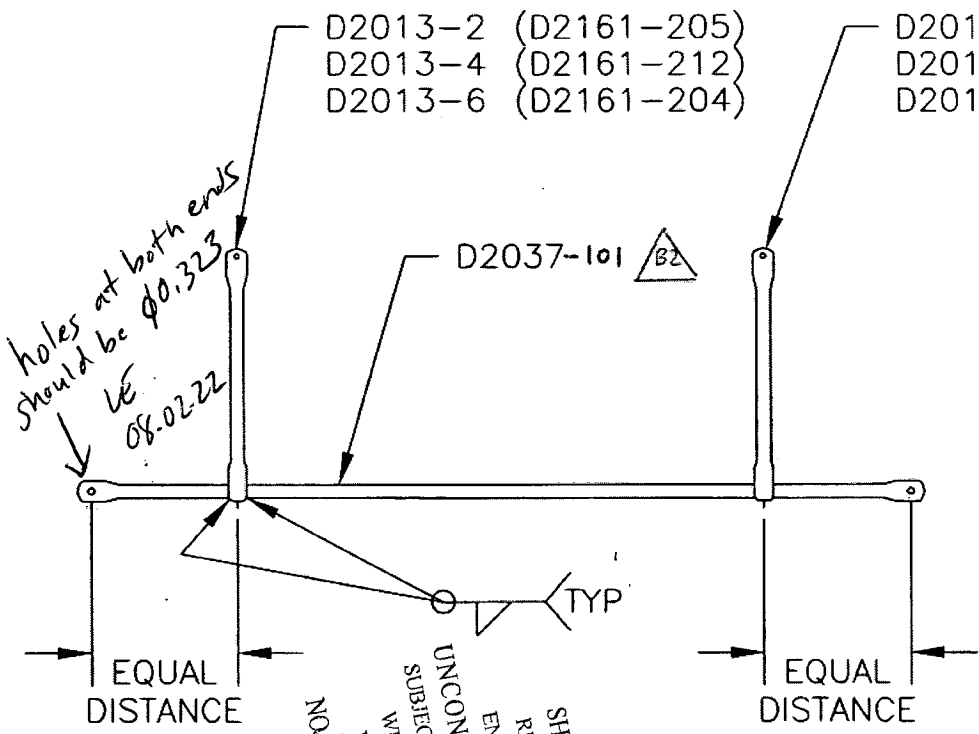
PLACE SHORTER ARM
ON SIDE OF JIG DT8065
LABELED FWD (TYP)

D2037-101
WELD FLAT
END PARALLEL TO
THE SHORT ARM

DETAIL OF D2161-204
DETAIL OF D2161-205
DETAIL OF D2161-212

D2013-2 (D2161-205)
D2013-4 (D2161-212)
D2013-6 (D2161-204)

D2013-1 (D2161-205)
D2013-3 (D2161-212)
D2013-5 (D2161-204)



NOTE: WELD ASSEMBLY
USING JIG DT8065

FINISH: ~~POWDER COAT ASSEMBLY BLACK~~
~~CRINKLE (4.3.5.3) PER DART QSI 005 4.3~~
~~POWDER COAT BLACK SANDTEX (4.3.5.7) PER~~
~~DART QSI 005 4.3~~ B1

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ENGINEERING
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WORK ORDER
NO. 36919